

Work Order ID 111674***111674***

Page 1

Friday, January 17, 2014 11:09:20 AM

Item ID: D119-646-143

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: 1-17-17Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3905-043	C								
IIN-D119-646	B								

100 0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D119-646-143
CHG 003

110 0.00

110

Skidtubes

Memo

0.00

Skidtubes

1- Inspect Mat'l D2500-1-190 for damage
2- Ensure squareness of ends

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/17/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2014 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 Chemical Conversion Coat per QSI005 4.1

0.00

120

0.00

HandFinish

Memo

Hand Finishing

130 QC7-Inspect Chemical Conversion Coat

0.00

130

0.00

QC

Memo

Quality Control

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Item ID: D119-646-143**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Repl Skidtube W/ Wearplates & Wearpads Apical Float**Start Date:** 1/17/2014 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/24/2014 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

150

Skidtubes

Memo

0.00

1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill first side only.

2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes.

3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477

4- Scribe batch # inside aft end of tube

155

0.00

155

CNC Bend 1

Memo

0.00

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

CNC Delta 100 Bender

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

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Item ID: D119-646-143 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 1/17/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 1/24/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

Skidtubes

Memo

0.00

Skidtubes

1- Veriffy dimation of bend as per dwg D3905

2- Buff out marks left from bending.

3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, spot face most fwd, top facing wearplate holes to 0.5626" to accomodate insert (1 per side) open to finished size

4- Drill Aft wearplate and wearpad holes using DT9545 as per dwg D3905 detail H open to finished size

5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)
DO NOT OPEN FWD SADDLE HOLES

6- Deburr, blow out chips from inside of tube

7-Bond web in place as per Dwg D3905 & QSI 015.

A/RSikaflex-291 _____

Sikaflex expire date: _____

Start: _____

Time: _____

Finish: _____

Time: _____

***** (Adhere for 12 hours) *****

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Setup Start

NS1

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NS2

Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

0.00

200

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd.Use
bending aid DT9544 ensure proper positioning

2- Cut Fwd end of tube as per dwg.

VERIFY MEASUREMENT BEFORE CUTTING

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

0.00

210

0.00

Skidtubes

Memo

Skidtubes

1- Buff out marks left from bending

2- Drill Fwd cap holes using DT8215.

3- Open Fwd saddle holes to finished size as per dwg

4- Drill Fwd x-bolt hole using DT9816 and open to finished size as per dwg.

5- Drill 1.87" and 3.74 holes using DT9494 locate from FWD cap hole. (verify measurement) as per dwg DEO D3905-B-1.

6- Drill towring hole and open to finished size using DT9494

7- Drill wearplate holes using DT9613, open to finished size as per dwg D3905-043

8- Open FWD & AFT cap holes as dwg.

9- Deburr, blow out chips from inside of tube.

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.00

Quality Control

224

0.00

224

Skidtubes

Memo

0.00

Skidtubes

1- Countersink x-bolt holes as per dwg

2- Remove alodine prepare for welding

3- Insert x-bolt spacers

4- Weld x-bolt spacer as per dwg

A/R Alum rod Batch: _____

5- Grind welds flush as per dwg

6- Counter bore x-bolt holes as per dwg

7- Deburr

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
225	QC5- Inspect part completeness to step on W/O	0.00							
225									
QC	Memo	0.00							
Quality Control									
226	QC10- Inspect visual per QSI004- ground welds	0.00							
226									
QC	Memo	0.00							
Quality Control									
227	Pressure Wash per QSI005 4.3	0.00							
227									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating									
245	QC3- Inspect Part Finish	0.00							
245									
QC	Memo	0.00							
Quality Control									
250		0.00							
250									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3905.								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/RSikaflex-240/-291 _____ Sikaflex expire date: _____ 2- install plugs assembly with o-ring lube as per dwg. A/R o-ring lube 55 Batch: _____ 3 -Inspect for foreign objects as per QSI 024 4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-240/-291 _____ Sikaflex expire date: _____ 5- Wing Walk as per dwg QSI005 4.4 Batch: _____								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 111674

111674

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20
per chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-1-190

Manufactured

No

110

Each

81.0000

1

1

D2500-1-190

Ext'n -I' Beam Tube 4"

Location

Loc Qty

Loc Code

HALL

81

105279

80

80061

1

D2579

Manufactured

No

Each

19.0000

2

D2579

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

19

105932

19

D2855-3

Manufactured

No

270

Each

2.0000

2

2

D2855-3

Cap

Location

Loc Qty

Loc Code

FP001

2

102169

2

D3492-5

Manufactured

No

270

Each

144.0000

16

16

D3492-5

Plug

Location

Loc Qty

Loc Code

FP001

144

104854

65

105612

79

Picklist Print

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Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

270

Each

192.0000

16

16

NAS1611-005

O-RING

Location

Loc Qty

Loc Code

FP001

192

m125807

4

m126974

188

D3672-1

Manufactured

No

270

Each

936.0000

2

2

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FG

10

85222

10

ST060

926

103845

136

93886

522

99099

268

D3681-1

Manufactured

No

190

Each

212.0000

8

8

D3681-1

Spacer

Location

Loc Qty

Loc Code

LG001

212

102202

11

108647

65

109109

136

Picklist Print

Friday, January 17, 2014 11:09:49 AM

Work Order ID: 111674

111674

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D3846-1 Manufactured No 270 Each 19.0000 1 1

D3846-1

Gasket

Location

Loc Qty

Loc Code

FP001

19

51827

4

53735

15

D3846-11 Manufactured No 270 Each 47.0000 1 1

D3846-11

Gasket

Location

Loc Qty

Loc Code

FP002

47

93954

47

D3847-1 Manufactured No 270 Each 24.0000 8 8

D3847-1

Wearpad

Location

Loc Qty

Loc Code

FP001

24

88420

24

D3847-11 Manufactured No 270 Each 5.0000 1 1

D3847-11

Wearpad

Location

Loc Qty

Loc Code

FP001

5

88556

5

Picklist Print

Friday, January 17, 2014 11:09:50 AM

Work Order ID: 111674

111674

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D3847-043

Manufactured No

270

Each

5.0000

1

1

D3847-043******

Fwd Wearplate Assy, Std/ Float Gear

LocationLoc QtyLoc Code

FP002

5

51820

1

52533

2

88540

2

D3847-045

Manufactured No

270

Each

7.0000

1

1

D3847-045******

Center Wearplate Assy, Std/Float

LocationLoc QtyLoc Code

FP002

7

87210

4

88242

3

D3847-049

Manufactured No

270

Each

6.0000

1

1

D3847-049******

Aft Wearplate Assembly, Float Gear

LocationLoc QtyLoc Code

FP002

2

88267

2

ST500

4

93904

4

D3885-3

Manufactured No

170

Each

9.0000

1

1

D3885-3******

Standard Web

LocationLoc QtyLoc Code

LG002

9

52425

1

99134

8

. Picklist Print

Friday, January 17, 2014 11:09:50 AM

Work Order ID: 111674

111674

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D3903-1	Manufactured	No	190	Each	69.0000	12	12
---------	--------------	----	-----	------	---------	----	----

D3903-1******

Spacer

LocationLoc QtyLoc Code

LG001

69

109112

69

D3672-3	Manufactured	No	270	Each	866.0000	12	12
---------	--------------	----	-----	------	----------	----	----

D3672-3******

Phenolic Washer

LocationLoc QtyLoc Code

FG

111

84432

11

89273

100

FP001

87

107316

87

ST060

500

110251

500

ST061

168

93925

168

D3683-3	Purchased	No	250	Each	271.0000	12	12
---------	-----------	----	-----	------	----------	----	----

D3683-3******

Insert

LocationLoc QtyLoc Code

ST061

271

47805

271

ALS4-1032-130	Purchased	No	250	Each	1,817.000	42	42
---------------	-----------	----	-----	------	-----------	----	----

ALS4-1032-130******

Rivnut

LocationLoc QtyLoc Code

st510

1817

M126109

1817

Friday, January 17, 2014 11:09:50 AM

Shop Packet Print

Picklist Print

Page 6

Friday, January 17, 2014 11:09:50 AM

Work Order ID: 111674

111674

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 270 Each 111.0000 44 44

AN3C5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
122800	5	
ST350	106	
m127290	106	

NAS1149C0332R Purchased No Each 11,236.00 44

NAS1149C0332R

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	1229	
125654	1229	
st510	10007	
m126319	2107	
m127306	2500	
m127410	3000	
m127831	2400	

NAS1149C0463R Purchased No Each 500.0000 12

NAS1149C0463R

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	21	
119097	21	
ST292	479	
123248	1	
123355	178	
m127306	300	

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Shop Packet Print

Page 6

Picklist Print

Friday, January 17, 2014 11:09:51 AM

Work Order ID: 111674

111674

Parent Item: D119-646-143

D119-646-143

Parent Item Name: Repl Skidtube W/ Wearplates & Wearpads Apical Float

Start Date: 1/17/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039C4-08

Purchased

No

270

Each

144.0000

12

12

MS27039C4-08

SCREW

Location

Loc Qty

Loc Code

ST308

144

m126319

144

MS24694-C52

Purchased

No

Each

150.0000

2

MS24694-C52

SCREW

Location

Loc Qty

Loc Code

ST301

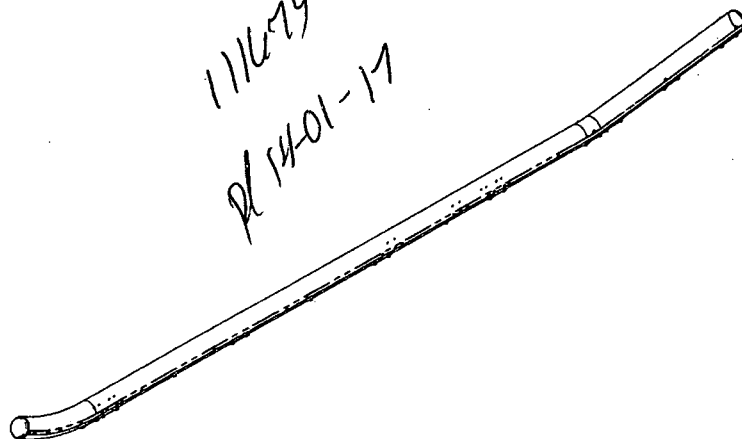
150

124308

50

m127059

100



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs
 D3905-043 = 47.0 lbs
 D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
10	2	2	2	D2579	CROSS BOLT SPACER
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	2	2	2	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28		16		D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	44	44	12	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	44	44	8	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW
49	2	2	2	MS24694-C52	SCREW

RELEASED
 2013-03-19

C	(SHT 1 P/L, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 46, ADD ITEM 48, MS24694-C52 WAS AN3C5A, D3672-1 AND NAS1149C0332R (ZN C7-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.204 THRU (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C8-7, D8-7)	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3846-047 WAS D3846-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE IV (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3905	SHEET 1 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	A119 FLOAT SKIDTUBE ASSY	
DATE	13.02.21	NTS	

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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3846-11
GASKET

D3847-11
WEARPAD

MS27039C4-08 SCREW
NAS1149C0463R WASHER
D3672-3 WASHER
12 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø 0.197
8 PL PER SIDE
REF

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

AN3C5A BOLT
NAS1149C0332R WASHER
36 PL

PLUG INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
6 PL

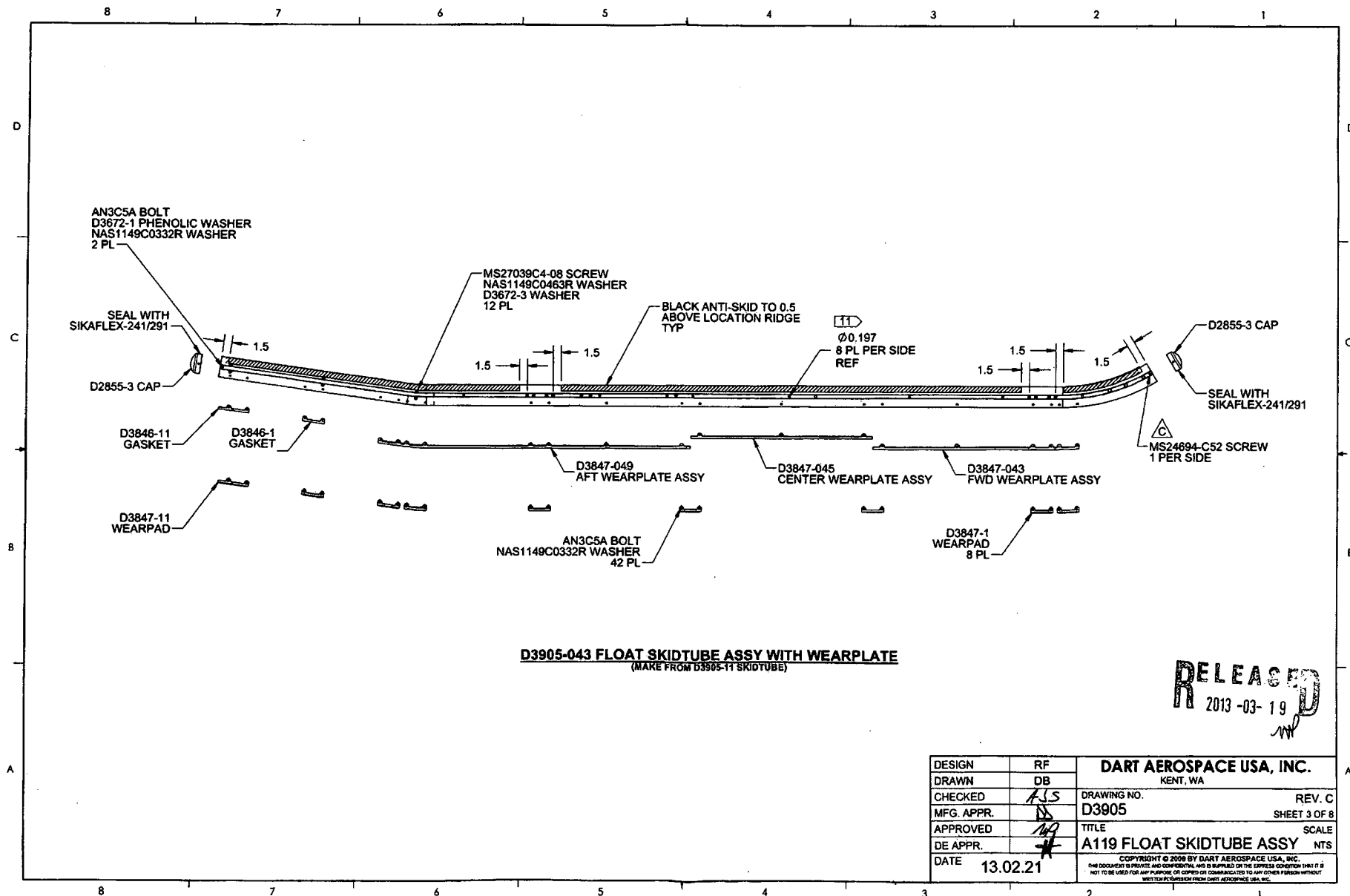
D3846-1
GASKET
8 PL

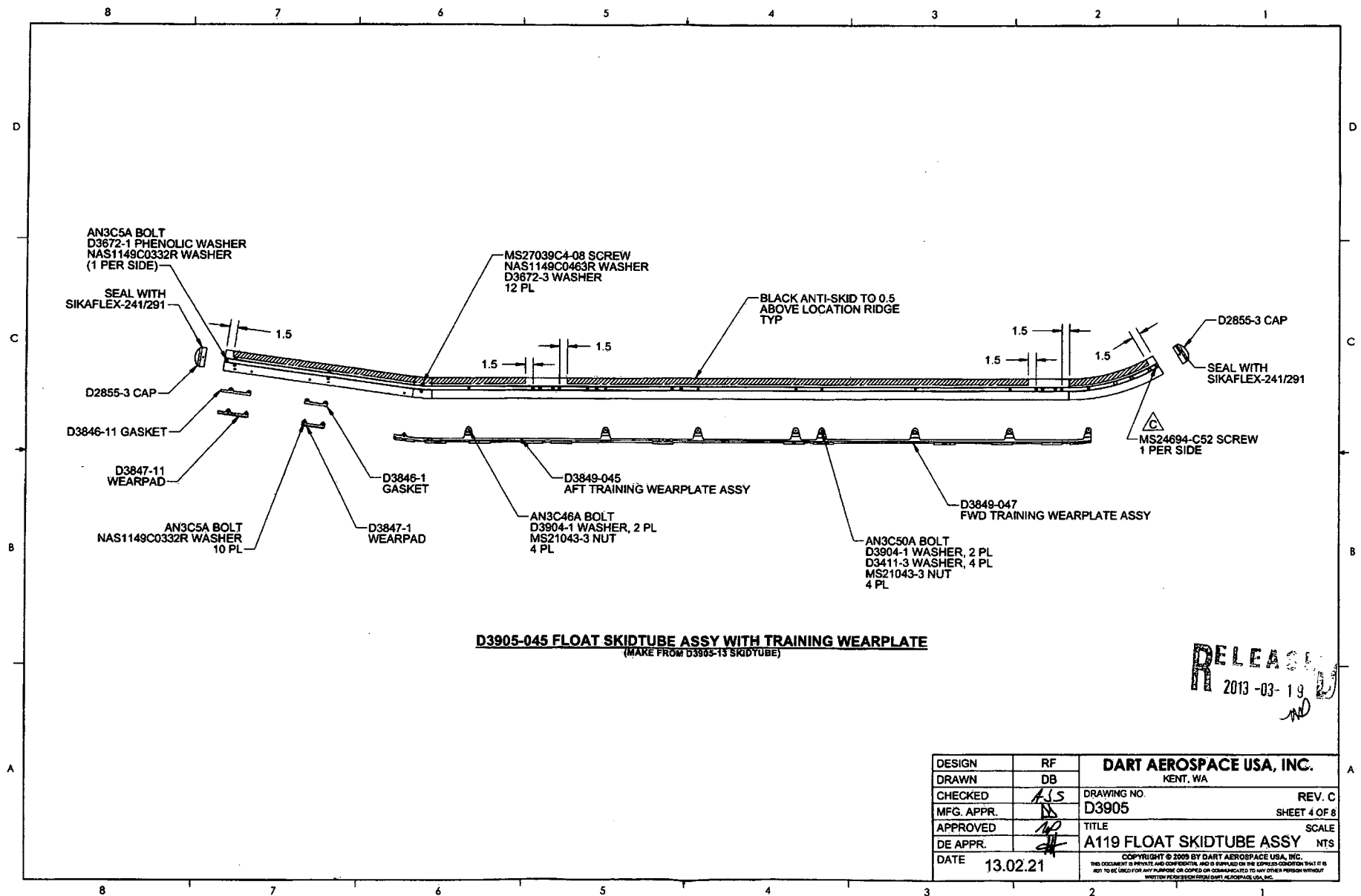
D3847-1
WEARPAD
8 PL

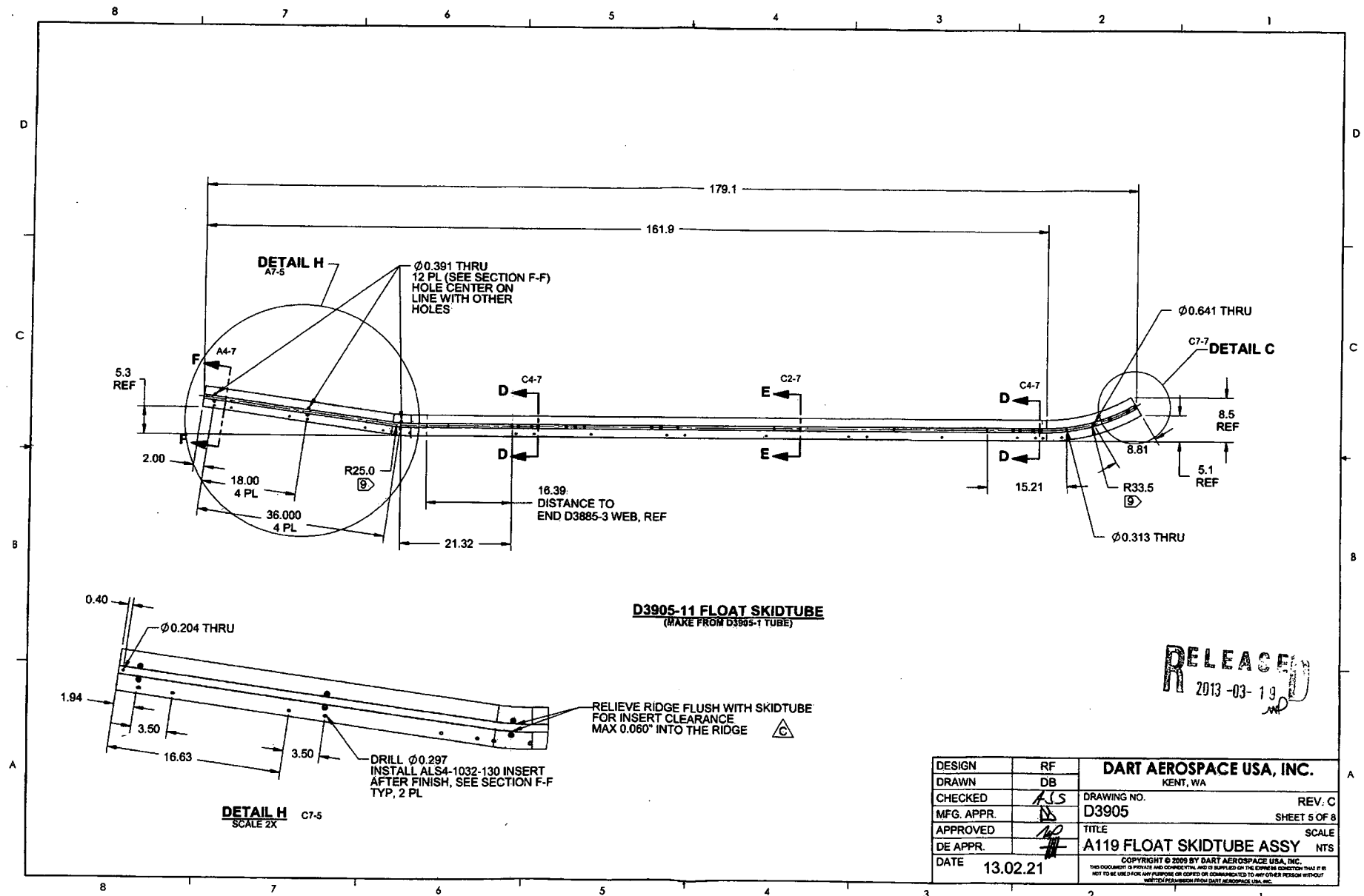
D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3905-11 SKIDTUBE)

RELEASE
R 2013-03-19
JW

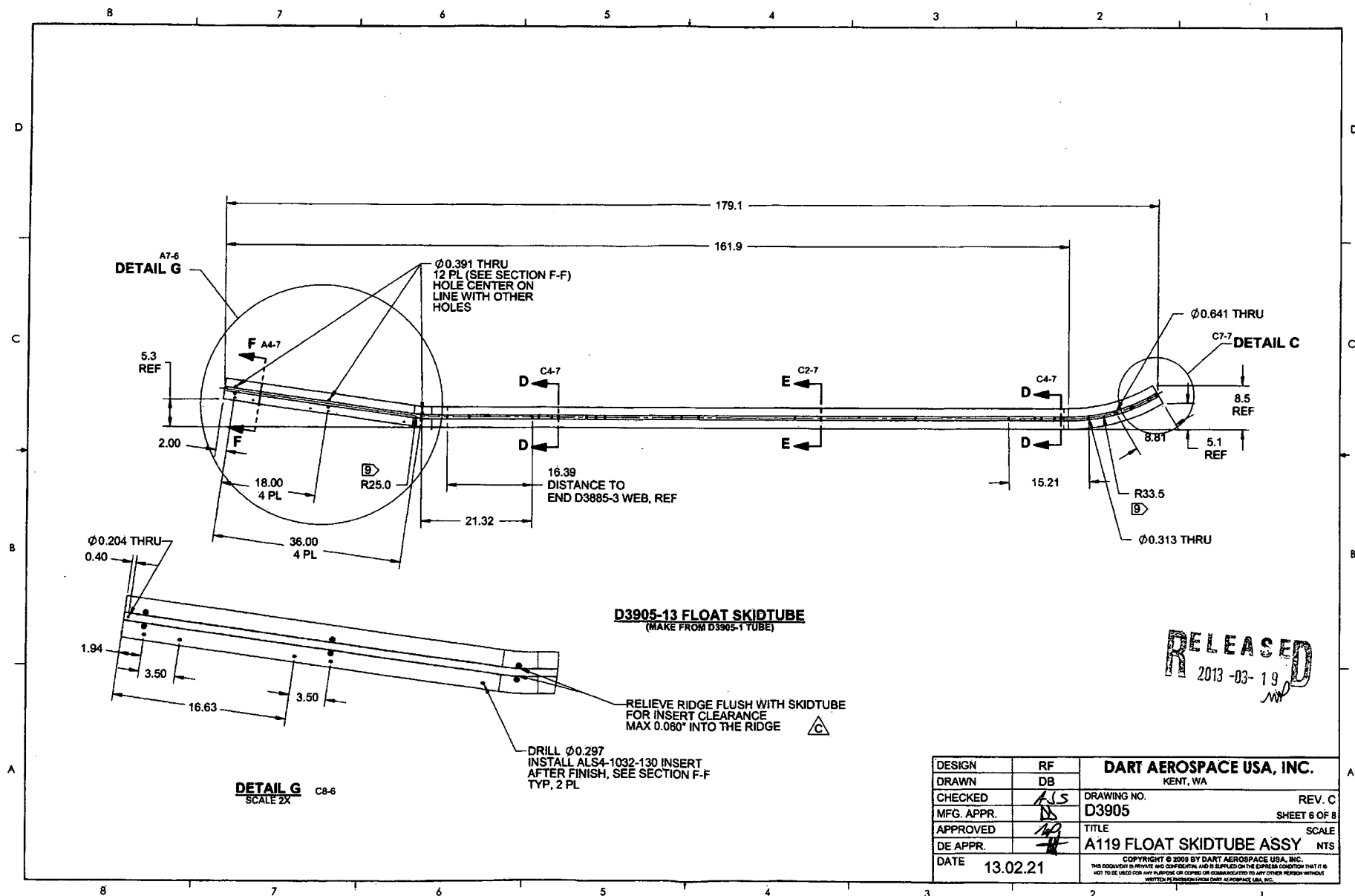
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DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3905	SHEET 2 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	SH	A119 FLOAT SKIDTUBE ASSY	NTS
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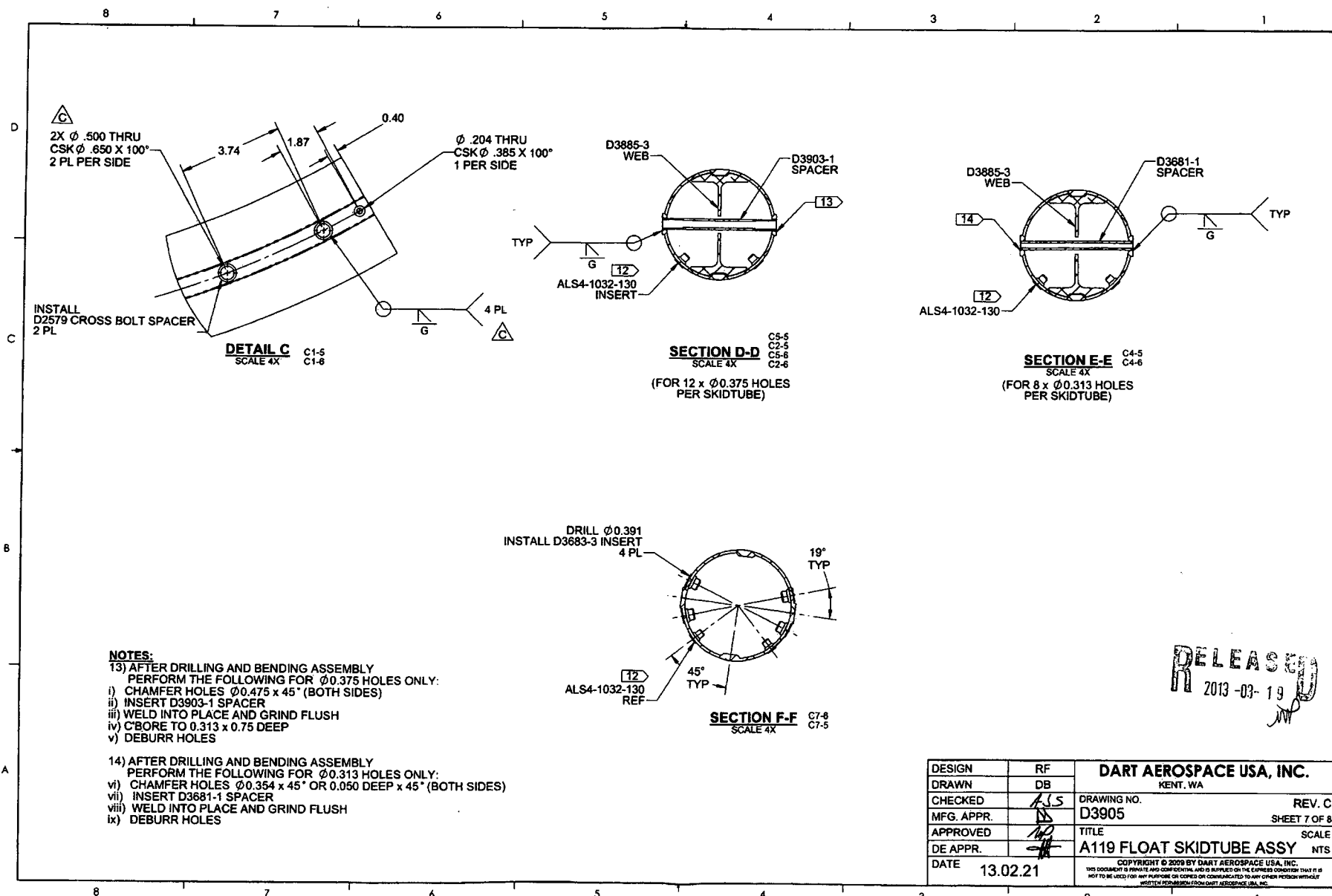


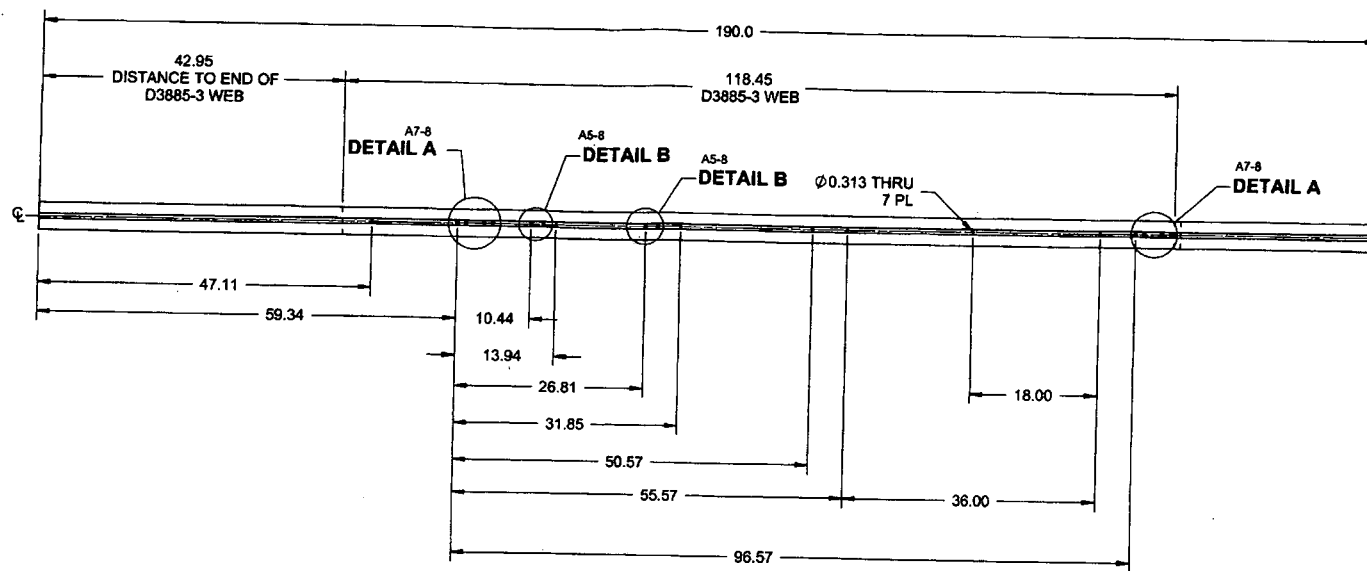




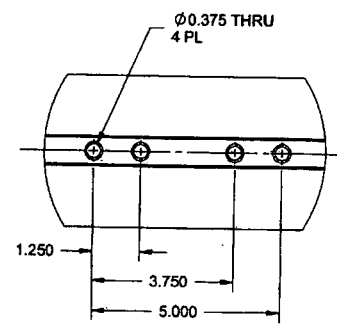
RELEASED
2013-03-19



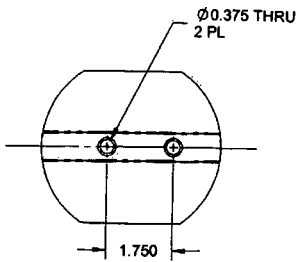




D3905-1 TUBE
(MAKE FROM D2500-1-150 EXTRUSION)



DETAIL A
SCALE 4X
D6-8
D2-8



DETAIL B
SCALE 4X
D5-8
D4-8

RELEASED
2013-03-19

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DRAWN	DB	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>NS</i>	D3905	SHEET 8 OF 8
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	A119 FLOAT SKIDTUBE ASSY	NTS
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